

Work Order ID 83188

April-13-12 1:00:44 PM

83188

Page 1

Item ID: D3674-041

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Item Name: BRACKET ASSEMBLY

Stop *NS2*

Start Date: 13/04/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 27/04/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 12/04/13

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3674	Rev A								

100

0.00

100

BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blanks: (1.250" x 2.000") 5.400" long

12 ✓ Jan T

110

0.00

110

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Machine D3674-1 as per Folio FA732 and Dwg D3674 Identify as D3674-12-Deburr3-Scribe batch number

12 ✓ 12/05/30

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Memo

0.00

Quality Control

12 ✓ 12/05/30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 83188

April-13-12 1:00:44 PM

83188

Page 2

Item ID: D3674-041

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: BRACKET ASSEMBLY

Stop ***NS2***

Start Date: 13/04/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 27/04/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC8- Inspect parts - second check	0.00							
130									
QC	Memo	0.00							
Quality Control									
140		0.00							
140	Small Fab								
Small Fab	Memo	0.00							
Small Fab	Assemble D3674-041 as per Dwg D3674								
150	QC5- Inspect part completeness to step on W/O	0.00							
150									
QC	Memo	0.00							
Quality Control									

D.A 12/05/30

12

0

12

24/06/01

42

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Work Order ID 83188***83188***

Page 3

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N900040100Setup Start ***NS1***

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4

Cust Item ID:

Required Date: 27/04/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

160 Identify as per dwg & Stock Location: 236 0.00***160***

Packaging Memo 0.00

Packaging

12x 8p
12-6-5

170 QC21- Final Inspection - Work Order Release 0.00

170

QC Memo 0.00

Quality Control

12/6/5 MF
12-06-05

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Picklist Print

April-13-12 1:00:47 PM

Page 1

Work Order ID: 83188

83188

Parent Item: D3674-041

D3674-041

Parent Item Name: BRACKET ASSEMBLY

Start Date: 13/04/2012

Required Date: 27/04/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 08-04-25 JLM Verified By:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3121-241		Manufactured	No			100	Each	92.0000	1	4			
-----------	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--

D3121-241

Bearing Assembly

**

Location	Loc Qty	Loc Code
----------	---------	----------

ST235A	92	
67280	3	
71851	1	
79733	2	
80904	86	

D3121-21		Manufactured	No			140	Each	57.0000	1	4			
----------	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--

D3121-21

Bolt

**

Location	Loc Qty	Loc Code
----------	---------	----------

ST235	57	
66969	1	
82162	56	

M174B1.250X02.000		Purchased	No			140	f	17.8820	0.55	2.315789			
-------------------	--	-----------	----	--	--	-----	---	---------	------	----------	--	--	--

M174R1 250X02 000

17-4 SS Bar 1.250 x 2.00

**

Location	Loc Qty	Loc Code
----------	---------	----------

MAT050	17.882	
114899	2	
115806	3.272	
117483	9.9	
119231	2.71	

121449

121769

121449

121769

12/06/01

12/06/01

B83364 (124)

6.600' Jam

3.3'
3.3'

W/O:		WORK ORDER CHANGES					
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DART AEROSPACE LTD		Work Order: 83188
Description: Bracket		Part Number: D3674-1
Inspection Dwg: D3674	Rev: A	Page 1 of 2

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.960	+/-0.010	1.960	✓		SLO8	View
0.750	+/-0.010	0.749	✓			
0.605	+/-0.010	0.606	✓			
3.380	+/-0.010	3.375	✓			
2.430	+/-0.010	2.429	✓			
0.380	+/-0.010	0.377	✓			
0.73	+/-0.030	0.732	✓			
0.95	+/-0.030	0.945	✓			
2.140	+/-0.010	2.135	✓			
2.030	+/-0.010	2.027	✓			
4.718	+/-0.010	4.720	✓			
4.590	+/-0.010	4.586	✓			
0.863	+/-0.010	0.854	✓			
0.130	+/-0.010	0.130	✓			
4.600	+/-0.010	4.600	✓			
4.880	+/-0.010	4.887	✓			
5.139	+/-0.010	5.144	✓			
R0.25	+/-0.030	R.250	✓		Rad gauge	
0.080	+/-0.010	0.078	✓		SLO8	
0.300	+/-0.010	0.304	✓			
30°	+/-0.5°	30°	✓			
Ø0.573	+/-0.010	Ø0.573	✓			
0.720	+/-0.010	0.723	✓			
0.345	+/-0.010	0.349	✓			
Ø0.392	+0.002/-0.000	Ø0.3935	✓		SLO2	Mic
2.173	+/-0.010	2.174	✓		SLO8	
3.135	+/-0.010	3.135	✓			
3.963	+/-0.010	3.955	✓			
4.365	+/-0.010	4.365	✓			
0.664	+/-0.010	0.662	✓			
100°	+/-0.5°	100°	✓			
0.076	+/-0.010	0.073	✓			
0.200	+/-0.010	0.196	✓			
0.200	+/-0.010	0.198	✓			
R0.10	+/-0.030	R.100	✓		Rad gauge	
0.032	+0.000/-0.010	0.026	✓		SLO8	

DART AEROSPACE LTD		Work Order:	
Description: Bracket		Part Number:	D3674-1
Inspection Dwg: D3674 Rev: A		Page 2 of 2	

FIRST ARTICLE INSPECTION CHECKLIST

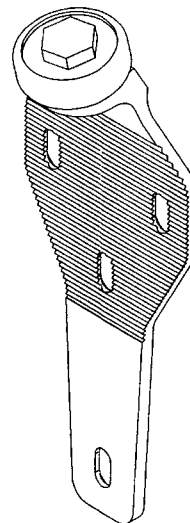
☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.050	+/-0.010	.050	✓		SLO8	View
0.025	+/-0.010	.025	✓		SLO8	
0.75	+/-0.030	.749	✓		SLO8	
R0.375	+/-0.010	R.375	✓		Rad gauge	
10-32 UNF-3B	N/A	10-32 UNF	✓		Thread gauge	
Ø0.201 x 100 DP	+/-0.010	Ø.201 x .104	✓		SLO8	View
R0.20	+/-0.030	R.200	✓		Rad gauge	

Measured by: <i>ST</i>	Audited by: <i>D.A</i>	Prototype Approval:	N/A
Date: 12/05/29	Date: 12/05/30	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.07.25	New Issue P/O D3674-041	KJ/DD <i>ST</i>	<i>DA</i>

QTY -041	PART NUMBER	DESCRIPTION
X	D3674-041	ROLLER BRACKET ASSEMBLY
1	D3121-21	BOLT
1	D3121-241	BEARING ASSEMBLY
1	D3674-1	BRACKET



D3674-041 BRACKET ASSEMBLY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 83188 MLJ
12/04/13

RELEASED
08-06-26

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: N/A
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.23 lbs
- 8) TORQUE D3121-21 BOLT 15-25 in lbs (1.7-2.8 Nm)

A	NEW ISSUE	AJS	08.03.26
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS		
DRAWN	ALB		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.03.26		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3674	REV. A SHEET 1 OF 4
TITLE ROLLER BRACKET ASSEMBLY	SCALE NTS
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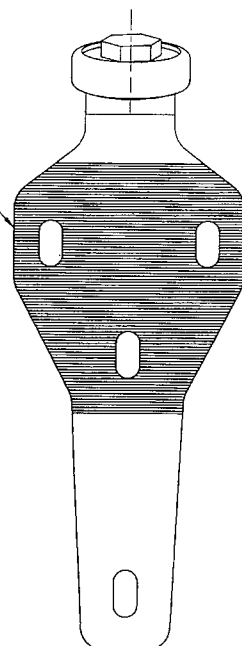
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

83188

D3674-1 BRACKET



D3674-041 BRACKET ASSEMBLY

D3121-21 BOLT

D3121-241 BEARING ASSEMBLY



RELEASED
08.03.26

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D3674	SHEET 2 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	ROLLER BRACKET ASSEMBLY	NTS
DATE	08.03.26	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

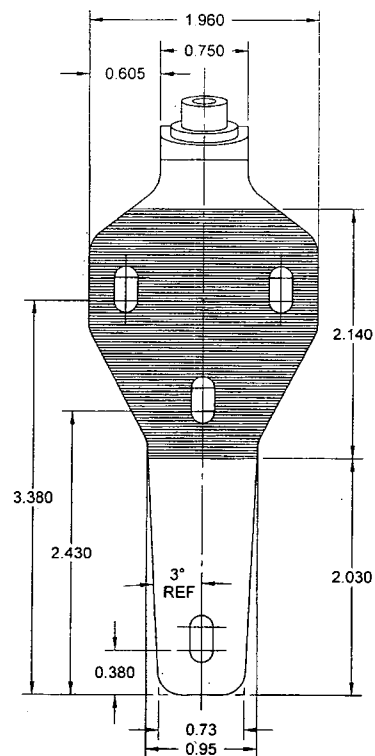
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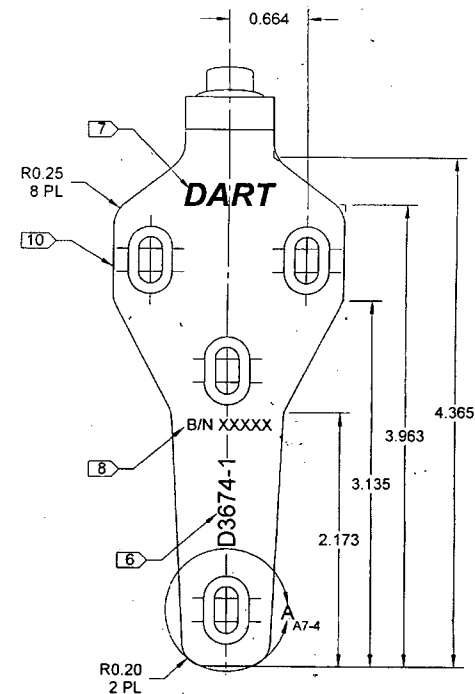
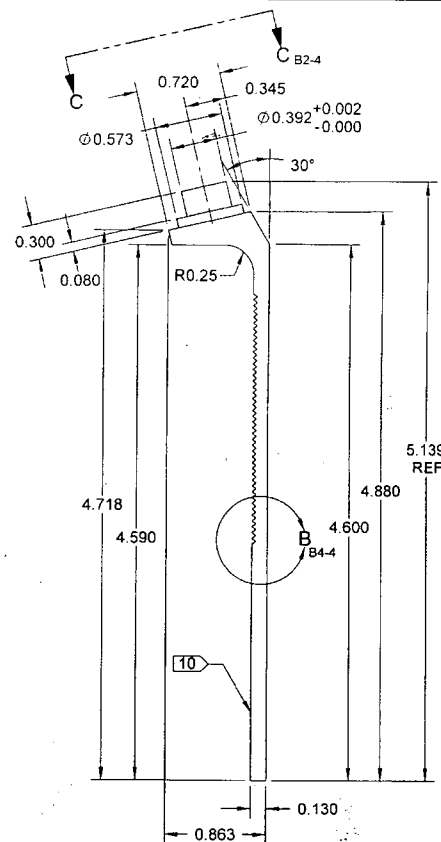
NOTE: Date & initial all entries



D3674-1 BRACKET

NOTES:

- 1) MATERIAL: 17-4 PH. STAINLESS STEEL BAR
PER AMS 5604/5643
GRAIN DIRECTION MUST BE ALONG THE LENGTH OF THE BRACKET
MINIMUM YIELD TENSILE STRENGTH = 100 ksi
MINIMUM ULTIMATE TENSILE STRENGTH = 150 ksi
(REF. DART SPEC. M17-4-B)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE WITH DART P/N "D3674-1" WITH 0.15 HIGH LETTERS TO A
MAX DEPTH OF 0.010 IN AREA SHOWN.
- 7) IDENTIFICATION: ENGRAVE DART LOGO WITH 0.20 HIGH LETTER TO A
MAXIMUM DEPTH OF 0.010 IN AREA SHOWN
- 8) IDENTIFICATION: SCRIBE DART B/N USING VIBRATING STYLUS
- 9) WEIGHT: 0.03 lbs
- 10) BASIC PROFILE OF D3674-1 BRACKET TAKEN FROM D3121-141 REF.



RELEASED
26-06-2014

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3674	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		ROLLER BRACKET ASSEMBLY	NTS
DATE	08.03.26	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

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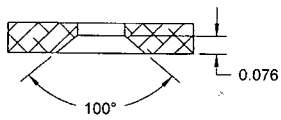
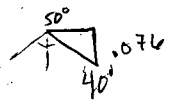
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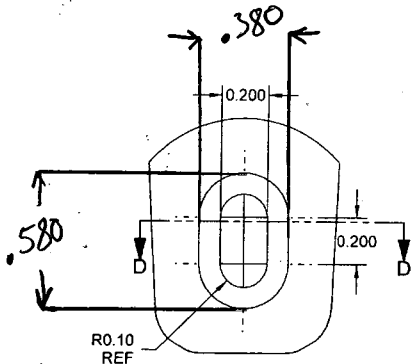
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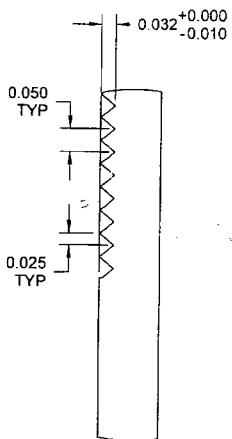
83188



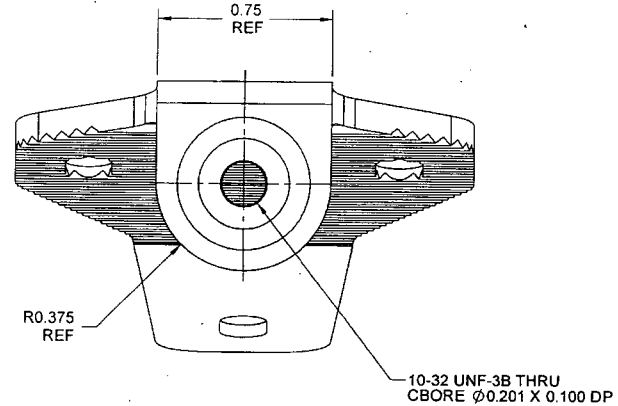
SECTION D-D



DETAIL A ^{B2-3}
SCALE 2X
(SLOT DETAIL 4PL)



DETAIL B ^{C4-3}
SCALE 4X
(RIDGE DETAIL)



VIEW C-C ^{D3-3}
SCALE 2X

RELEASED
08-06-26 MJD

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DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
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